

Work Order ID 55463

January 19, 2010 9:49:52 AM

Page 1

Item ID: D3204-11

Accept

Revision ID:

Item Name: Plate

Start Date: 1/19/10 Start Qty: 10.00

Required Date: 1/25/10 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: *R*

Date: *10-1-19* Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3204	Rev A1
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100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3204 : Dwg Rev: *A1* : Prog Rev: *A1* : 2-

Deburr if necessary

6061 375X1

B 10-1-25

(38)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 10-1-25

120

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

1-Face to size .300" : 2-Open hole to .191" as per Dwg D3204: i3-Deburr

SL 1/10/125

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

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Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC2- Inspect parts off machine FAI/FAIB

0.00

21 10/01/25

QC

Memo

0.00

Quality Control

140

QC8- Inspect parts - second check

0.00

28 10/01/25

QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location 45

0.00

Packaging

Memo

0.00

Packaging

10-1-25

38x SP

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Work Order ID 55463

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Page 3

Item ID: D3204-11

Accept



Setup Start



Revision ID:

Stop



Item Name: Plate

Start Date: 1/19/10 Start Qty: 10.00



Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/26
MF
10-1-26

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Picklist Print

January 19, 2010 9:49:56 AM

Page 1

Work Order ID: 55463

Parent Item: D3204-11

Parent Item Name: Plate

Start Date: 1/19/10

Required Date: 1/25/10

Comments: IPP: 05.08.11 Added Step 25... KJ/JLM
IPP Rev:D Now on Waterjet 08-01-08 JLM Verified By:EC

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B0.375X01.00 0		Purchased	No			100	f	21.6358	1.1189	4.3		



6061T6 BAR .375 x 1.00



B 10-1-05

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

21.63578948

105225

5.3

2.83578948

113325

13.5

113328

38

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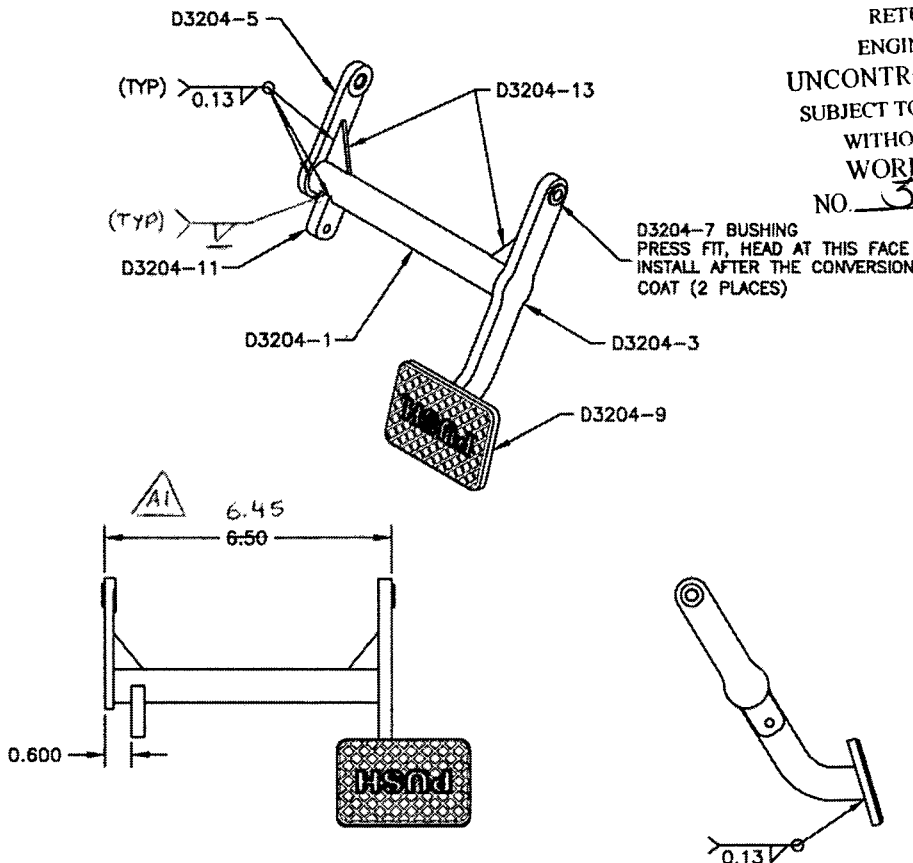
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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY		SCALE NTS
A	04.01.27	NEW ISSUE	
AI	05.07.15	6.45 WAS 6.50	

RELEASED
04.04.30



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WITHOUT NOTICE
WORK ORDER
NO. 35463

D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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Dart Aerospace Ltd

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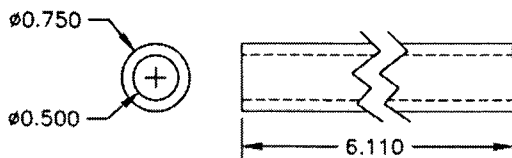
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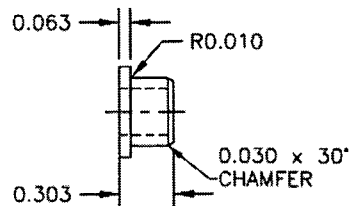
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DART

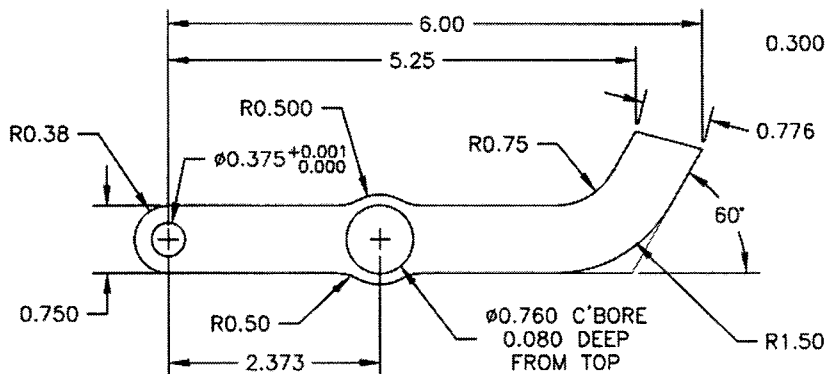
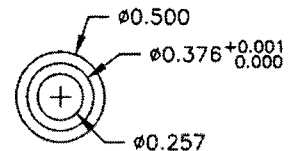
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CHECKED H	APPROVED H	DRAWING NO. D3204	REV. A SHEET 2 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

RELEASED
04.04.05 H

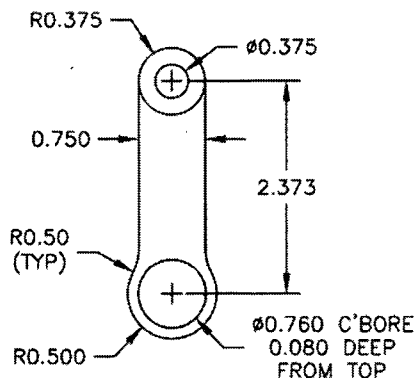
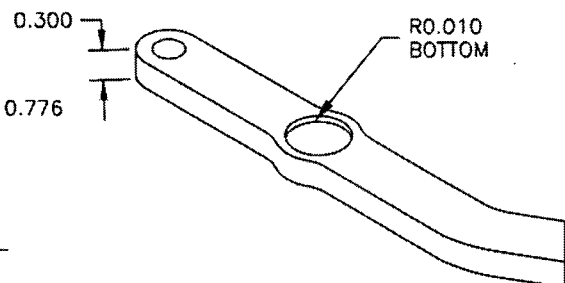
2 **D3204-1 TUBE**
SCALE 1:2



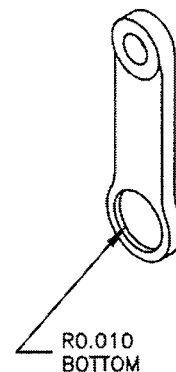
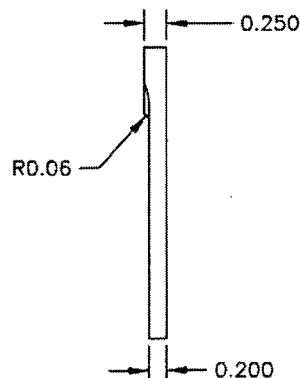
4 **D3204-7 BUSHING**
SCALE 1:1



3 **D3204-3 ARM**
SCALE 1:2



3 **D3204-5 ARM**
SCALE 1:2



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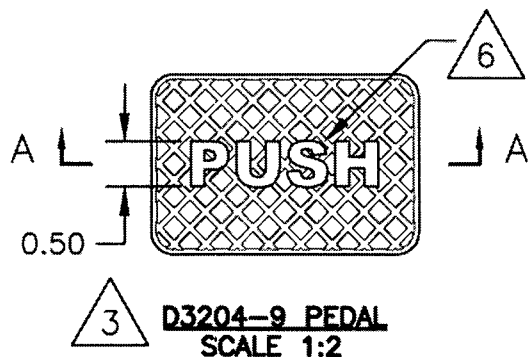
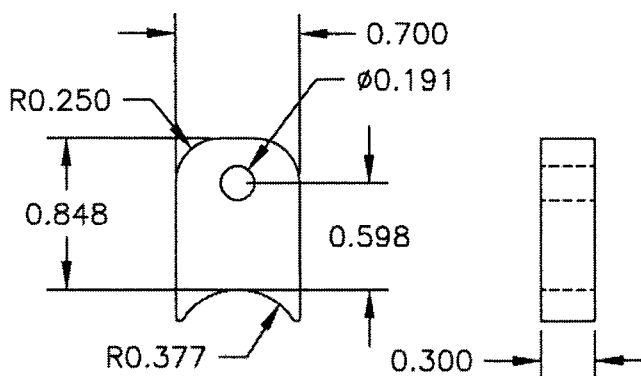
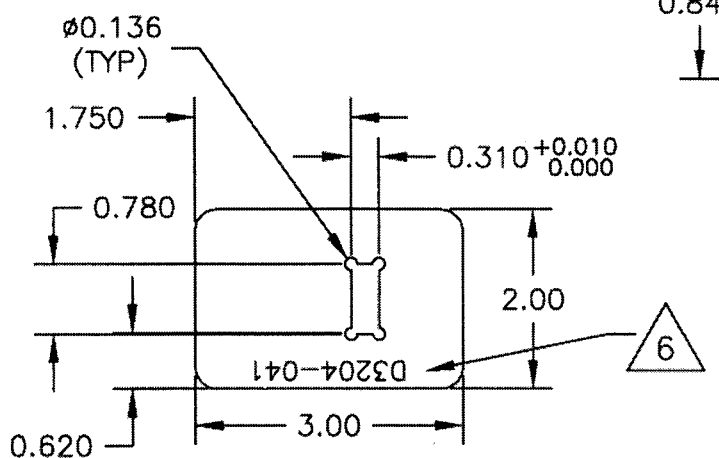
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W16 55463

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04.04.30



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